Monday, 22/10/2007 2:17:22 PM
Linda Lacelle

Split 07.12.12

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 35298 -2
Estimate Number : 12884
P.O. Number : N/A
This Issue : 22/10/2007 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : SMALL /MED FAB
Previous Run : 35032
Written By :
Checked & Approved By :
Comment : Est Rev:A New Issue 07.05.24 EC
Est Rev B ECN 987 07.10.09 EC verified by DD

Drawing Name : ARM
Part Number : D3560044
Drawing Number : D3560 UNDER REVIEW
Project Number : N/A
Drawing Revision : C
Material : N/A
Due Date : 29/10/2007 Qty: 1 Um: Each

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0500X05000	6061-T6 Bar .50" x 5.0"

Comment: Qty.: 1.3598 f(s)/Unit Total : 19.0365 f(s)
6061-T6 Bar 0.50" x 5.00"
Batch: 7106152

07/11/30

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks 15.500" long

07/11/30

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA696 Rev: AA & Dwg D3560 Rev: C

2-C'sink 0.196" hole on manual mill as per dwg D3560

3-Deburr per dwg D3560

07/12/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/12/07

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK

07.12.07

Form: rprocess

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 35298

Part Number: D3560044

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	D35921	PLATE

Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)

PLATE B 35331

07.12.13

Seq. #:	Machine Or Operation:	Description :
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

07.12.13

STEP:

1- clean material (buff bracket and bottom of arm with blue pad) 1L
2- set up bracket and arm on jig 1L
3- preheat bracket and arm with torch 1L
4- clean before welding with brush 1L
5- set up machine to 135 amps 1L
6- weld across bottom and top ends 1L
7- reheat with torch (60°) 1L
8- on one side weld from bottom to top half way 1L
9- same for other side (half way) 1L
10- from half way point weld the rest of the first side (ease off pedal near end) 1L
11- same for remaining side (ease off pedal near end) 1L

07.12.13

Seq. #:	Machine Or Operation:	Description :
8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

07/12/13 (1)

Seq. #:	Machine Or Operation:	Description :
9.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

07/12/13 (1)

Seq. #:	Machine Or Operation:	Description :
10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07.12.13

(6)

Form: rprocess

Date: Monday, 22/10/2007 2:17:22 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** ARM

Job Number: 35298 **Part Number:** D3560044

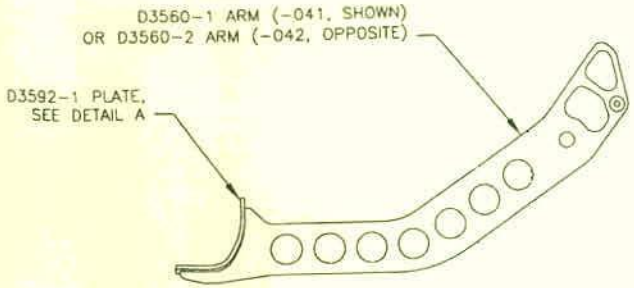
Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	07-12-13 1
12.0	D2808	Spacer
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s) Spacer batch: D 3533O	MF 07-12-13
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Press bushing in D3560 arm per dwg D3562	MF 07-12-13 (1)
14.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	07/12/13 (2)
15.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: WH	07-12-13 (3)
16.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07/12/13 (6)

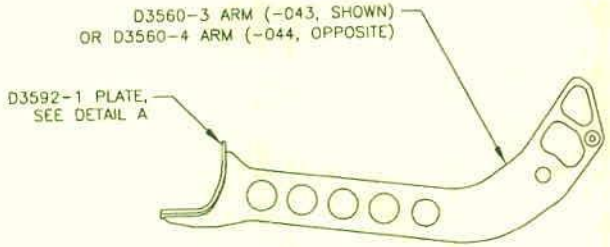
Job Completion

07.12.13

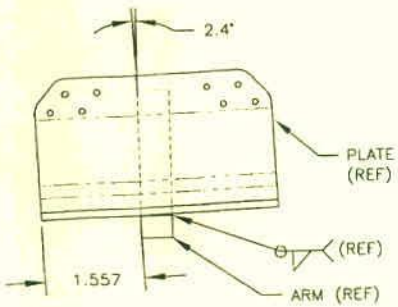
Form: rprocess

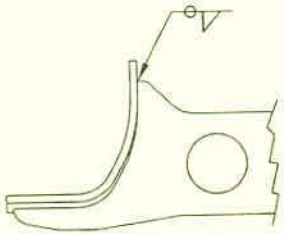


D3560-041 ARM WELDMENT (SHOWN),
D3560-042 ARM WELDMENT (OPPOSITE)



D3560-043 ARM WELDMENT (SHOWN),
D3560-044 ARM WELDMENT (OPPOSITE)





DETAIL A
(SCALE 1:1)

GENERAL NOTES
1) WELD PER QSI 004
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

RELEASED
07.06.24
UNDER REVIEW
07.10.22 DC

C	07.06.19	REMOVE POWDER COAT
B	07.01.15	REDESIGN AS WELDMENT, ADD POCKETS
A	06.09.25	NEW ISSUE

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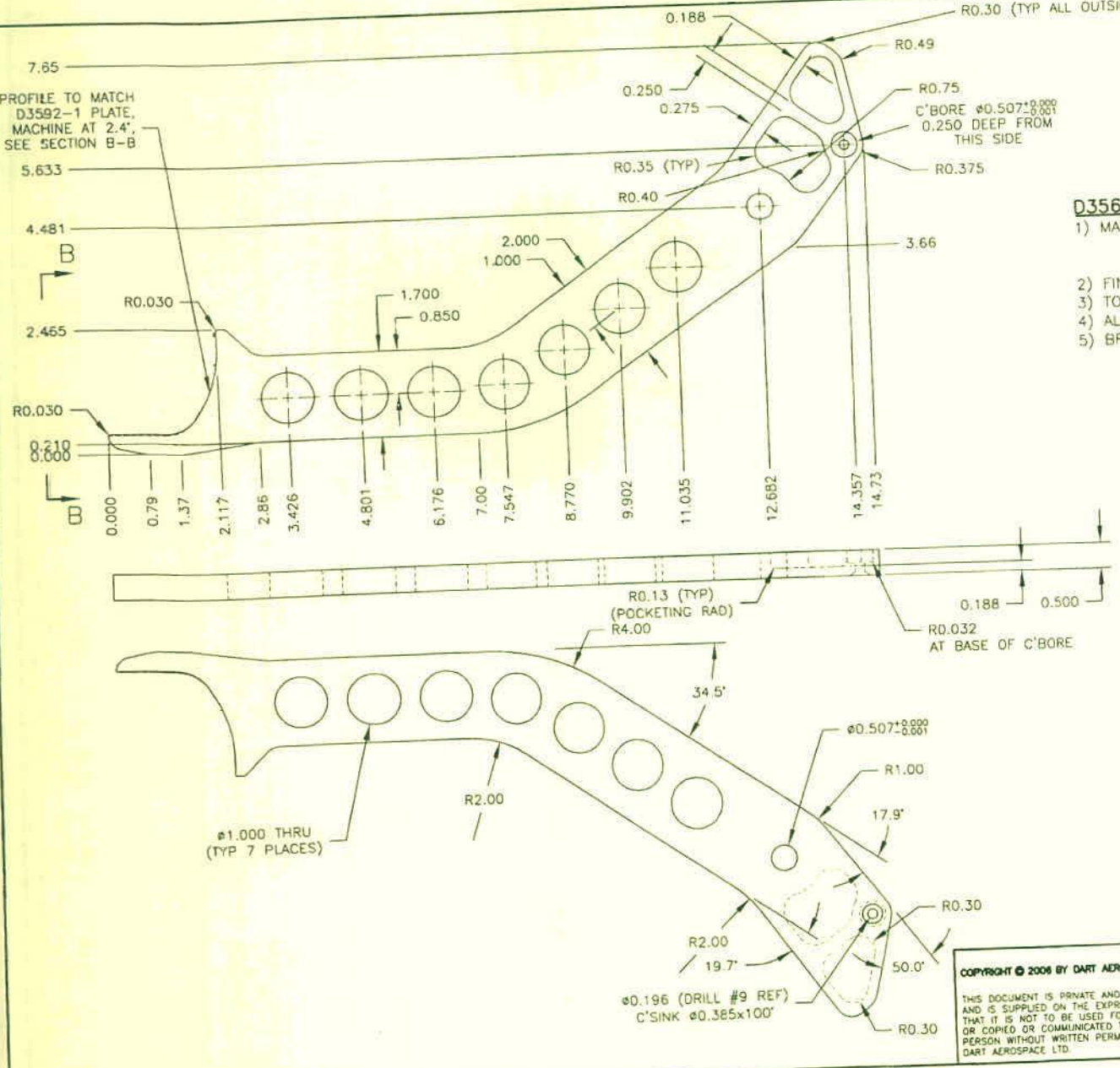
DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3560	REV. C SHEET 1 OF 3
DATE 07.06.19		TITLE ARM WELDMENT	SCALE 1:4

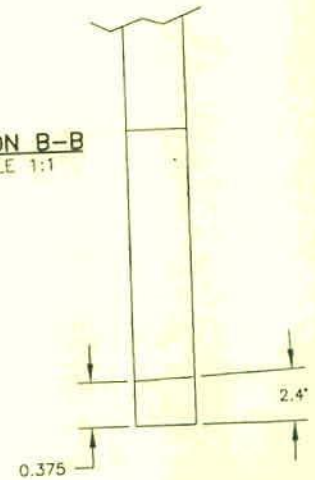


D3560-1 ARM (SHOWN), D3560-2 ARM (OPPOSITE)

1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION B-B

SCALE 1:1



RELEASED
07.06.29

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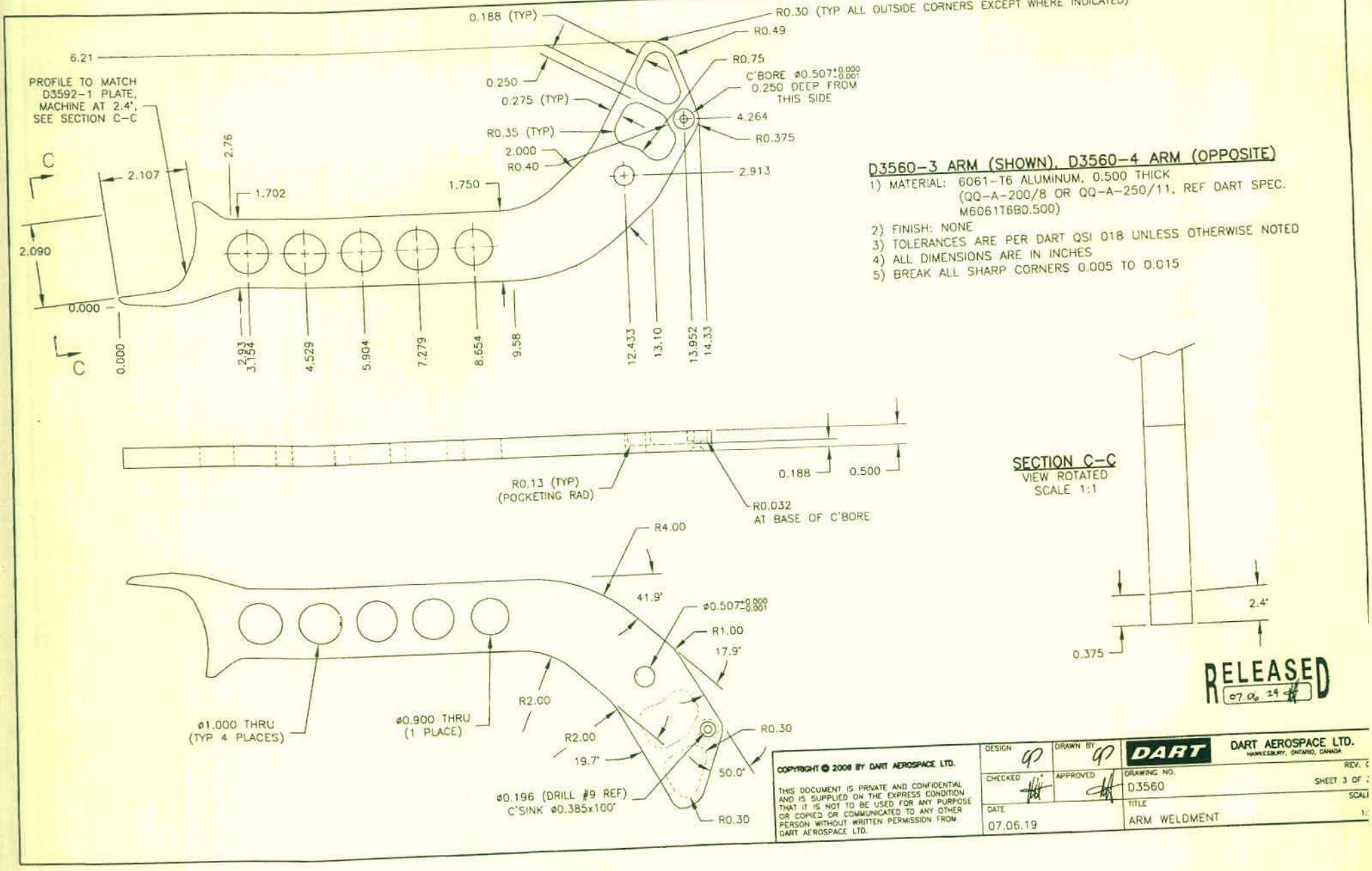
CHECKED	APPROVED	DRAWING NO. D3560 — REV. — SHEET 2 OF — SCA
DATE 07.06.19		TITLE ARM WELDMENT



D3560-3 ARM (SHOWN), D3560-4 ARM (OPPOSITE)

1) MATERIAL: 6061-T6 ALUMINUM, 0.500 THICK (QQ-A-200/8 OR QQ-A-250/11, REF DART SPEC. M6061T6B0.500)
2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP CORNERS 0.005 TO 0.015

SECTION C-C
VIEW ROTATED
SCALE 1:1

RELEASED
07.06.29

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CHECKED	APPROVED	DRAWING NO. D3560 — REV. C — SHEET 3 OF 3
DATE 07.06.19		TITLE ARM WELDMENT — SCALE 1:1

DART AEROSPACE LTD	Work Order:	3524
Description: Arm	Part Number:	D3560-4
		Page 1 of 1
Inspection Dwg: D3560 Rev: B		

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	.507				
Ø0.196	+0.005/-0.001	.196				
Ø1.000	+0.010/-0.001	1.000				
Ø0.900	+0.010/-0.001	.899				
0.500	+/-0.010	.504				
0.250	+/-0.010	.254				
0.275	+/-0.010	.276				
0.188	+/-0.010	.187				
2.000	+/-0.010	2.004				
1.750	+/-0.010	1.752				
1.702	+/-0.010	1.704				
Ø0.385 x 100°	+/-0.010 x 0.5°	.384				
0.250 Deep	+/-0.010	.252				

Measured by:	
Date:	07/12/07

Audited by:	
Date:	07/12/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	